

# Work Order ID 87073

July-10-12 2:50:21 PM

**\*87073\***

Page 1

Item ID: DSI 9410-011 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step Modification  
 Start Date: 7/10/12 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 8/03/12 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan:                      Date: 120711 Tooling:                      Date:                      Run Start **\*NR1\***  
 QC:                      Date:                      SPC (Y/N):                      Date:                      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9410	B

100		0.00							
<b>*100*</b>									
DC									
Document Control	Memo Photocopy bluefile & type labels per PPP DSI 9410-011 CHG002	0.00							

110	Pick Kit	0.00							
<b>*110*</b>									
Packaging									
Packaging	Memo	0.00							

120	QC4- 100% Inspect kits for completeness	0.00							
<b>*120*</b>									
QC									
Quality Control	Memo	0.00							

**DAS**  
16  
3-3  
12/07/13  
JB

**12-7-18**  
**5**

**5**

**DAS**  
16  
3-3  
12/07/13  
JB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

H:\FORMS\Quality Assurance\approved QANCRWO RevE

**NOTE:** Date & initial all entries

H:\FORMS\Quality Assurance\approved QANCRWO RevE

# Picklist Print

July-10-12 2:50:20 PM

Page 1

Work Order ID: 87073

Parent Item: DSI 9410-011

Parent Item Name: Step Modification

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP RevA: New issue DD verified by:EC  
by:EC IPP rev:B as per dwg RevB DD 10.03.03 verified

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-15A Bolt		Purchased	No			110	Each	520.0000	8	40			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				358		100							
				121652		100							
				GA		100							
				120449		100							
				ST358		320							
				118706		3							
				120422		1							
				122141		316							
AN960JD416 Washer	NAS1149D0463J	Purchased	No			110	Each	29.0000	16	80			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		29							
				116289		8							
				119097		21							
D2732-030 Rubber Cushion		Manufactured	No			110	Each	2.0000	4	20			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST402		2							
				84498		2							
D3595 - 200 - 300 Rubber Cushion (per sq ft)		Manufactured	No			110	sf	334.1500	0.0833	0.4165			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT052		334.15							
				68954		334.15							

x2

5/10/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 87073

Parent Item: DSI 9410-011

Parent Item Name: Step Modification

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 5.00

Required Qty: 5.00

MS21042L4

Nut

Purchased

No

110

Each

1,177.0000

8

40

Location

Loc Qty

Loc Code

ST300

1177

119075

116

121011

193

121444

699

121652

169

121444

JB 12/07/20

July-10-12 2:50:20 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND DRAWING D350-591 REV. F

REF. CANADIAN STC: SH92-6

FAA STC: SH967NE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 57073

0120711

TO IMPROVE THE FIT OF THE D350-591-311/-312 STEPS, IT IS ACCEPTABLE TO INSTALL THE DSI 9410-011 KIT. INSTALL THE D2732-030 CUSHION (AFT CROSSTUBE ) AND D3595-200-300 CUSHION (FWD CROSSTUBE) AS SHOWN IN FIGURE 1 IN PLACE OF THE D2856-400-720 ABRASION STRIP CALLED OUT ON DRAWING D350-591 REV. F.

FOR CUSTOMERS WHO HAVE PREVIOUSLY INSTALLED D2856-400-720 ABRASION STRIPS REMOVE THE ABRASION STRIPS IN ACCORDANCE WITH ICA-D350-591. PRIOR TO INSTALLING THE DSI 9410-011 KIT.

DSI 9410-011 KITS WILL BE INCLUDED WITH D350-591-311/-312 STEPS AT CHANGE 002 AND SUBSEQUENT.

QTY -041	PART NUMBER	DESCRIPTION
X	DSI 9410-011	STEP MODIFICATION KIT
4	D2732-030	CUSHION
2	D3595-200-300	CUSHION
8	AN4-15A	BOLT
16	AN960JD416	WASHER
8	MS21042L4	NUT (OR MS21042-4)

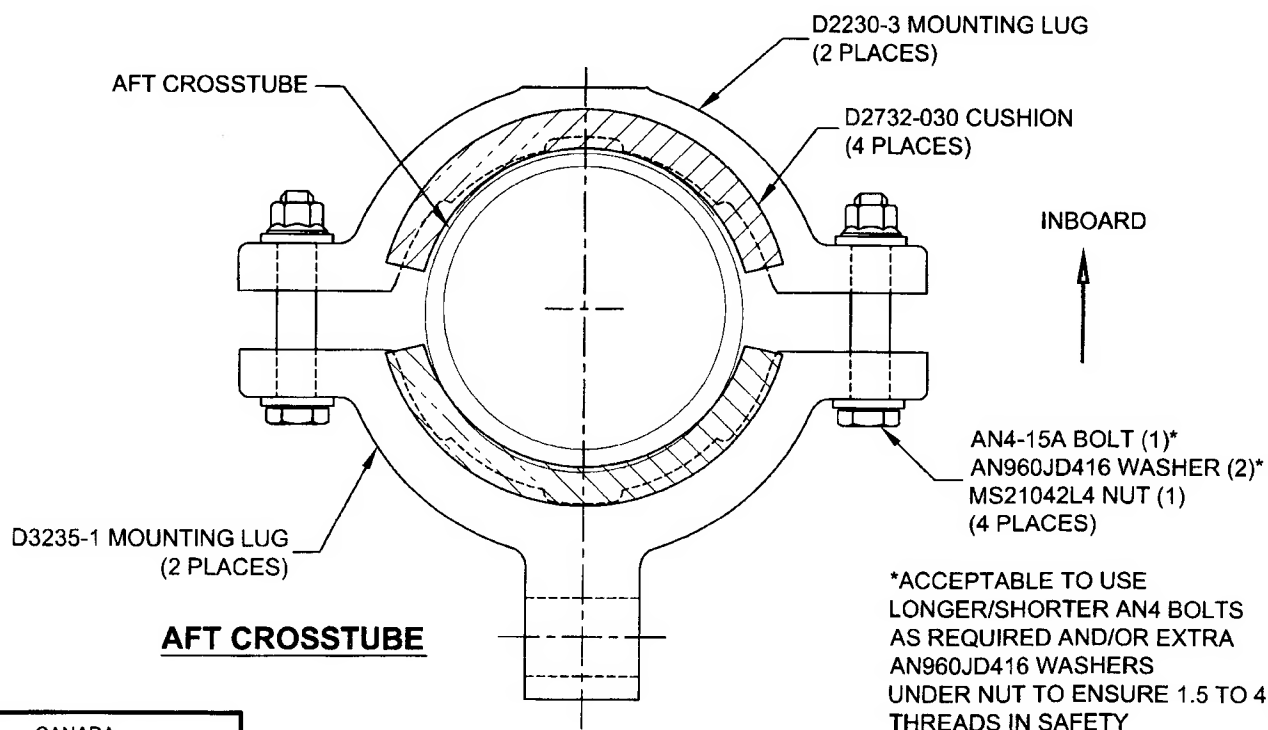
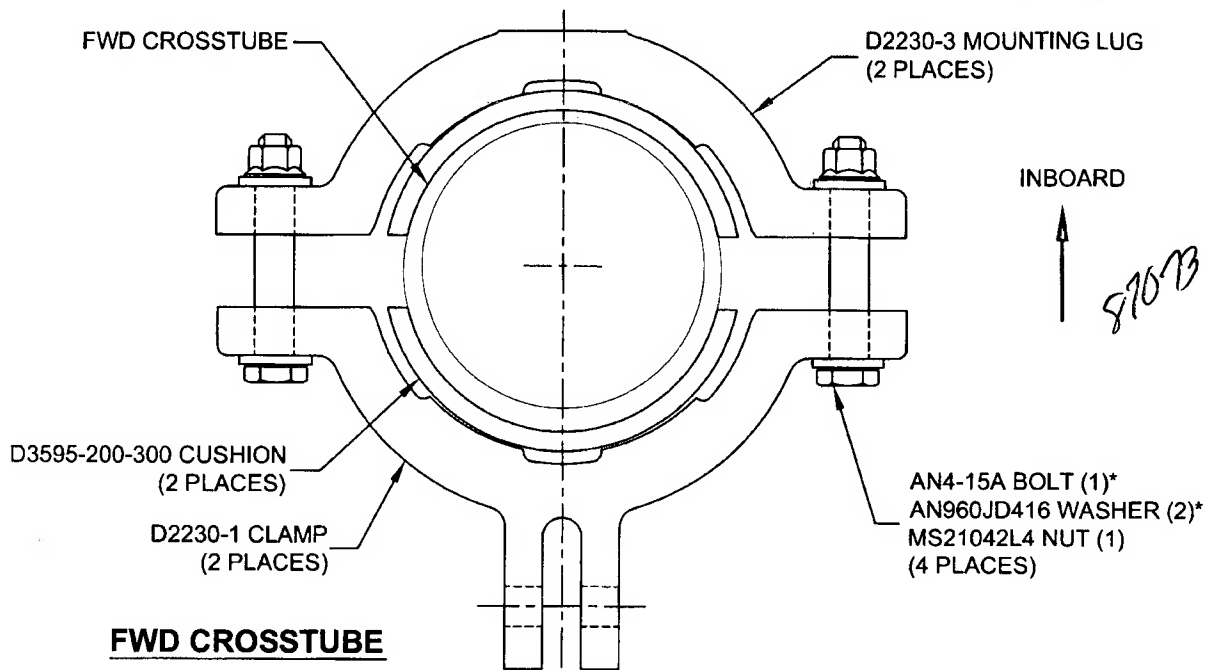
CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: [Signature]  
D. SHEPHERD (DE # 02)

DATE: 08.09.08  
CERT. NO.: SH92-6  
ISSUE NO.: 10

B	SHEET 1 DELETE REVISED P/L. (SEPERATE DSI KIT FROM MAIN KIT SEE NCR 08-082 FOR DETAILS)	AJS	08.09.08
A	NEW ISSUE	PH	08.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>AJS</u>	<b>DART AEROSPACE LTD</b>	
DRAWN	<u>AJS</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>[Signature]</u>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9410	SHEET 1 OF 2
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\*ACCEPTABLE TO USE  
LONGER/SHORTER AN4 BOLTS  
AS REQUIRED AND/OR EXTRA  
AN960JD416 WASHERS  
UNDER NUT TO ENSURE 1.5 TO 4  
THREADS IN SAFETY

**FIGURE 1 - CLAMP/CUSHION INSTALLATION**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**  
*[Signature]*  
BY: D. SHEPHERD (DE # 02)

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# **DART SERVICE INSTRUCTION**

TO AMEND DRAWING D350-591 REV. F

REF. CANADIAN STC: SH92-6

FAA STC: SH967NE

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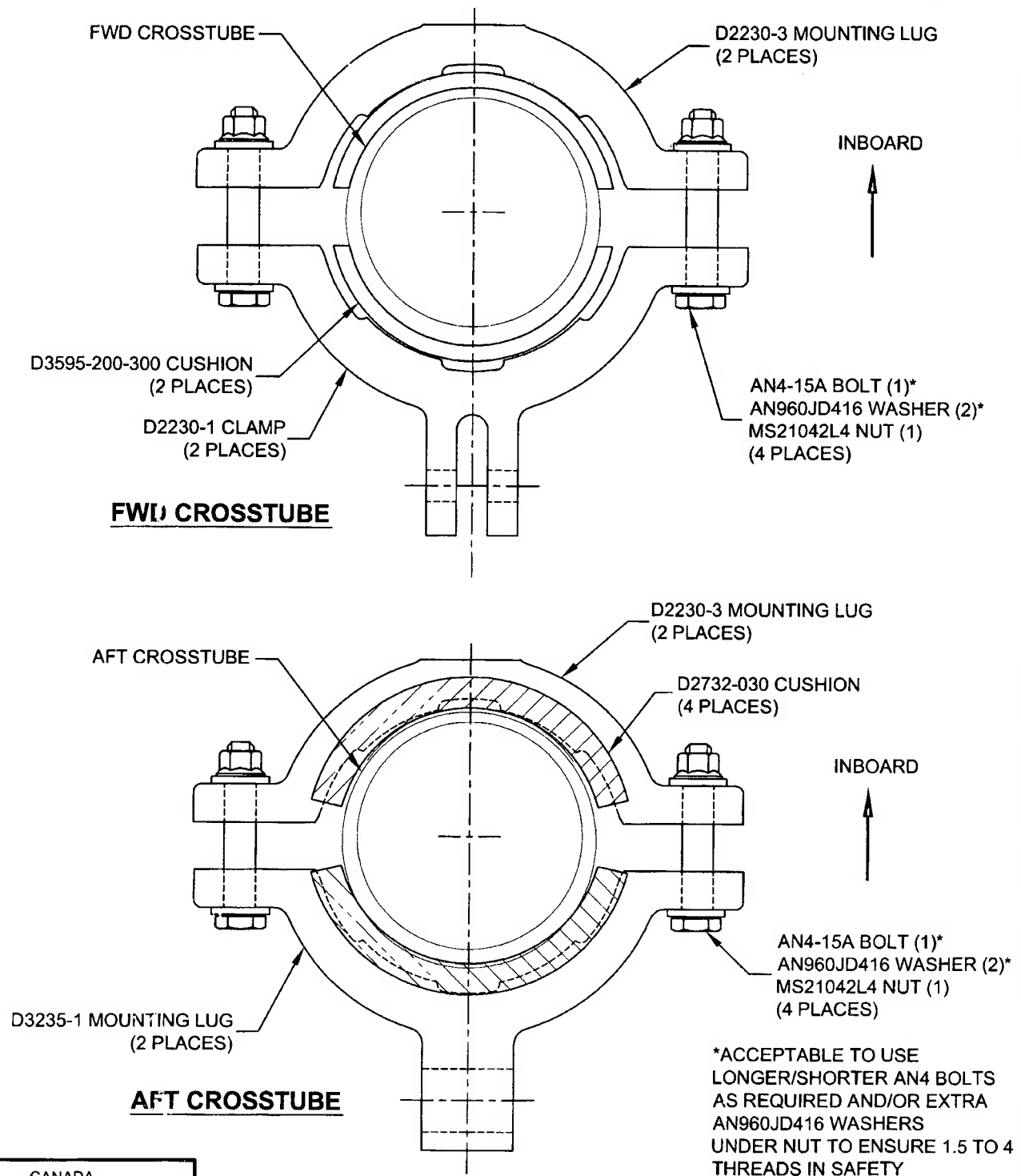
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DAO # 01-O-01

APPROVED

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DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9410	SHEET 1 OF 2
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**FIGURE 1 - CLAMP/CUSHION INSTALLATION**

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BRANCH  
DAO # 01-O-01

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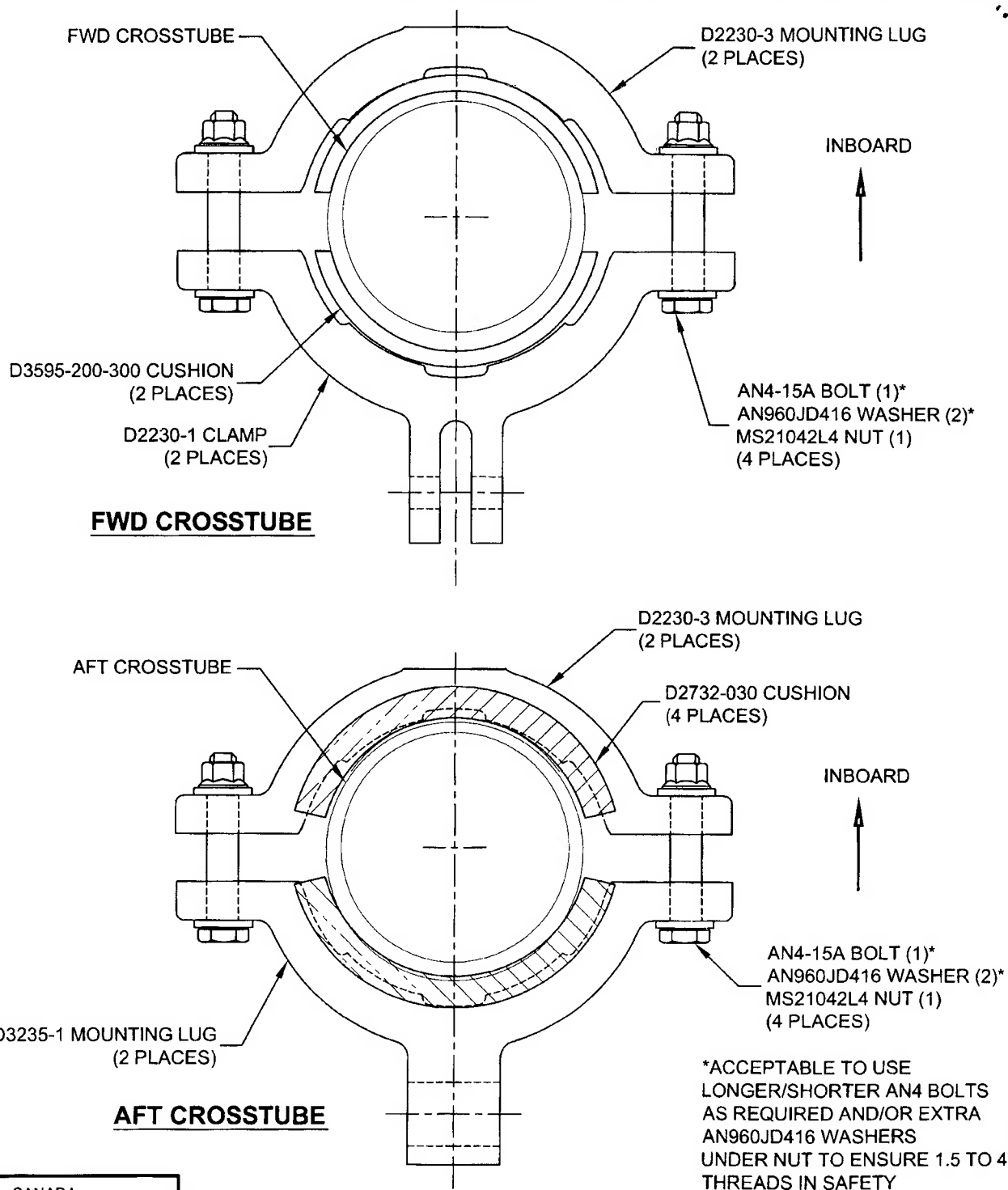
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**FIGURE 1 - CLAMP/CUSHION INSTALLATION**

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DEPARTMENT OF TRANSPORT  
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BRANCH  
DAO # 01-O-01

**APPROVED**

BY: *[Signature]*  
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